

Appl. No. 09/994,741
Amdt. dated 8/28/07
Reply to Office action of 5/29/07

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CLAIM AMENDMENTS

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claims 1 – 21 (canceled).

Claim 22 (new). A process for producing brochures in any formats and thicknesses by wire binding, the process comprising the following steps:

providing sheet-like printing materials having a margin and a row of perforations along the margin;

producing at least one wire binding element with random loop length and loop distance as required;

tailoring the at least one wire binding element to a respective format and thickness of a brochure having a plurality of the sheet-like printing materials, immediately prior to a binding process; and

inserting the wire binding element in the row of perforations for loosely binding the brochure.

Claim 23 (new). The process according to claim 22, which further comprises additionally tailoring the wire binding element to be produced to the row of perforations.

Claim 24 (new). The process according to claim 22, which further comprises:

Appl. No. 09/994,741
Amdt. dated 8/28/07
Reply to Office action of 5/29/07

- a) determining the format and thickness of a brochure to be bound and subsequently setting a production parameter for the wire binding element with an electronic control device;
- b) producing the wire binding element tailored to the format and thickness of the brochure with devices electronically and mechanically connected with one another by:
 - feeding a wire from at least one wire supply having a wire spool to a wire bending device;
 - bending the wire into a flat, loop-shaped wire binding element with the wire bending device;
 - cutting to length the wire binding element with a cutting device and feeding the cut wire binding element to an insertion device;
 - feeding a stack of the sheet-like printing materials, having the row of perforations, for binding;
 - inserting the wire binding element into the row of perforations in the stack of the sheet-like printing materials; and
 - subsequently bending the wire binding element with a bending and closing device into a closed ring-like binding.

Claim 25 (new). The process according to claim 22, which further comprises inserting a crimp into each loop of the wire binding element centrally with a crimping device.

Appl. No. 09/994,741
Amdt. dated 8/28/07
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Claim 26 (new). The process according to claim 25, which further comprises carrying out the step of inserting the crimp into the wire binding element in stages on a loop by loop basis with a single bending die.

Claim 27 (new). The process according to claim 22, which further comprises carrying out the wire binding with a single wire binding element corresponding to an entire width of the brochure.

Claim 28 (new). The process according to claim 22, which further comprises:
producing the wire binding with a plurality of individual wire binding elements distributed over a width of the brochure by insertion into the row of perforations;
and
simultaneously inserting the individual wire binding elements into the row of perforations for binding the brochure.

Claim 29 (new). The process according to claim 22, which further comprises:
producing the wire binding with a plurality of individual wire binding elements directly adjacent one another by insertion into the row of perforations; and
simultaneously inserting the individual wire binding elements into the row of perforations for binding the brochure.

Claim 30 (new). The process according to claim 22, which further comprises determining a production parameter of the wire binding element selected from the

Appl. No. 09/994,741
Amdt. dated 8/28/07
Reply to Office action of 5/29/07

group consisting of wire diameter, wire length, and diameter of the wire binding elements formed into the closed ring-like binding, with an electronic control device.

Claim 31 (new). The process according to claim 28, which further comprises determining a number of the individual wire binding elements to be maximally selected, in dependence upon the format of the brochure to be bound.

Claim 32 (new). The process according to claim 29, which further comprises determining a number of the individual wire binding elements to be maximally selected, in dependence upon the format of the brochure to be bound.